

Work Order ID 74512

Monday, October 03, 2011 2:37:31 PM



Page 1

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: M.C.J.V

Date: 11/10/03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-

Deburr if necessary

B11-10-28

B11-10-27

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-10-27

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/28

(12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74512

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Page 2

Item ID: D3535-15

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Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326
2-Form joggle as per Dwg D3535 using Jig DT8158
3-Identify as D3535-15

SP 11/10/31

(12)

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

11 10 31 (12)

150



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

Powder Coating

START TIME: 3:45

FINISH TIME:

OVEN TEMPERATURE:

3200K

4:15

12x4 m 11/11/01

M118434

Dart Aerospace Ltd

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Page 3

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Setup Start



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Stop



Item Name: Wearshoe

Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 BR 11-11-2

170

Identify as per dwg & Stock Location: FP-1

0.00



Packaging

Memo

0.00

Packaging

12 BR 11-11-2

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/2011

11-11-02
12

Dart Aerospace Ltd

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 2:37:36 PM

Page 1

Work Order ID: 74512

Parent Item: D3535-15

Parent Item Name: Wearshoe



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

170.5795

1.0205

12.89053



304/316 .040 Sheet

181-10-07

Location

Loc Qty

Loc Code

MAT020

170.5795

116623

0.2

117550

8.363

117933

45.3442

118400

33.6723

118964

83

119346

119346

12

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order: 74512
Description: Wearshoe		Part Number: D3535-15
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	✓		V IB02	
2.000	+/-0.010	2.003	✓		V	
5.650	+/-0.010	5.656	✓		T IB01	
9.150	+/-0.010	9.156	✓		T	
14.400	+/-0.010	14.406	✓		T	
19.650	+/-0.010	19.656	✓		T	
24.900	+/-0.010	24.906	✓		T	
30.150	+/-0.010	30.156	✓		T	
33.650	+/-0.010	33.656	✓		T	
35.650	+/-0.010	35.656	✓		T	
39.150	+/-0.010	39.156	✓		T	
Ø0.188	+0.005/-0.001	.191	✓		V	
24.00	+/-0.030	24.006	✓		T	
16.00	+/-0.030	16.006	✓		T	
8.00	+/-0.030	8.006	✓		T	
5.00	+/-0.030	5.006	✓		T	
0.300	+/-0.010	.304	✓		V	
0.300	+/-0.010	.305	✓		V	
0.038	+/-0.010	.038	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-10-07	Date: 11/10/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE

Dart Aerospace Ltd

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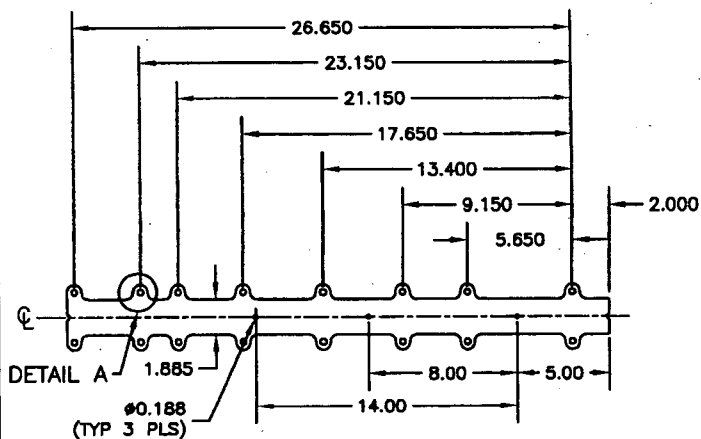
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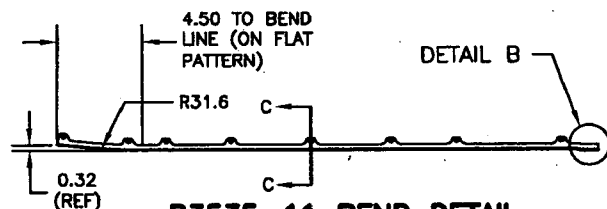
07.04.17

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74512 M.L.J

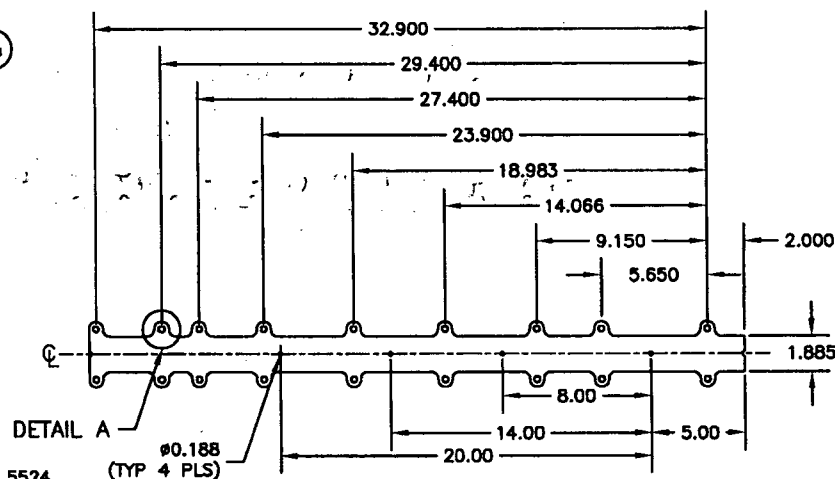
11/10/03



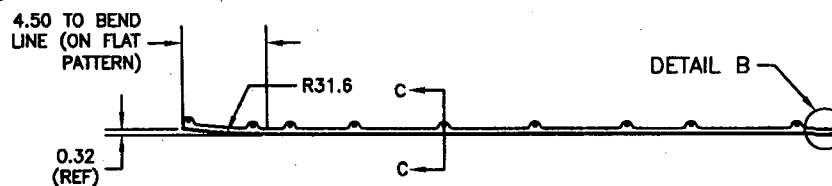
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \bar{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
07.04.17	06.10.25	D3535	SCALE
DATE	DATE	TITLE	SCALE
07.04.17	07.04.17	WEARSHOE	1:10
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

Dart Aerospace Ltd

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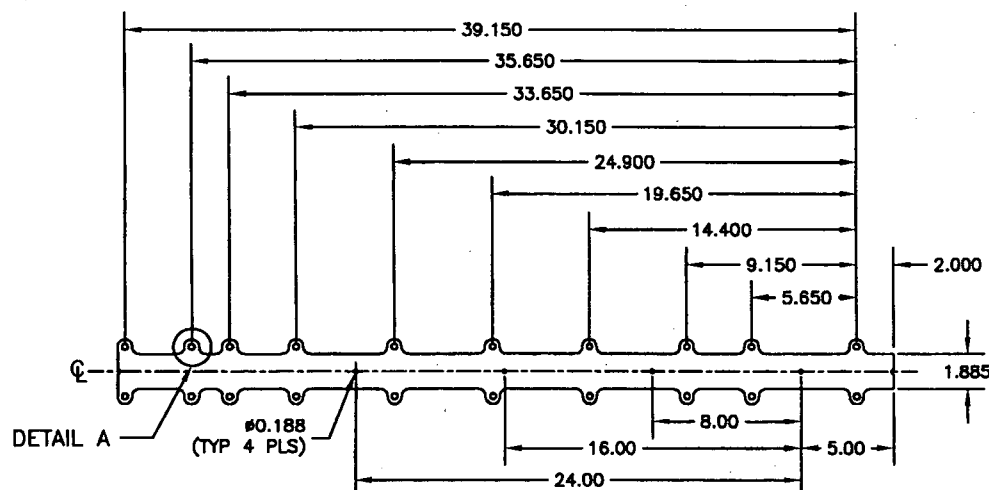
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DART

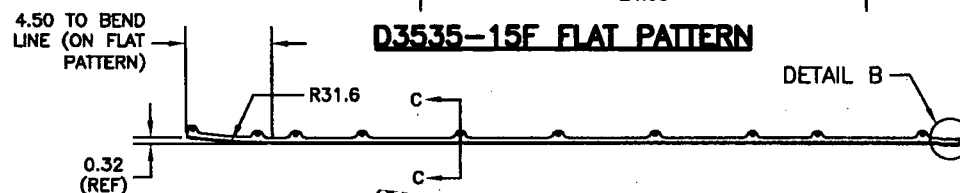
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07.04.24

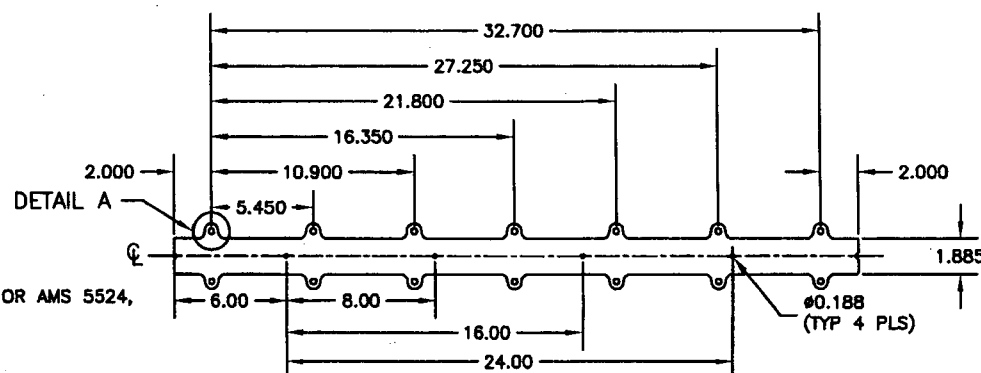
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 2 OF 7
				SCALE 1:10



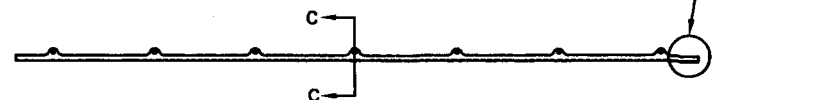
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

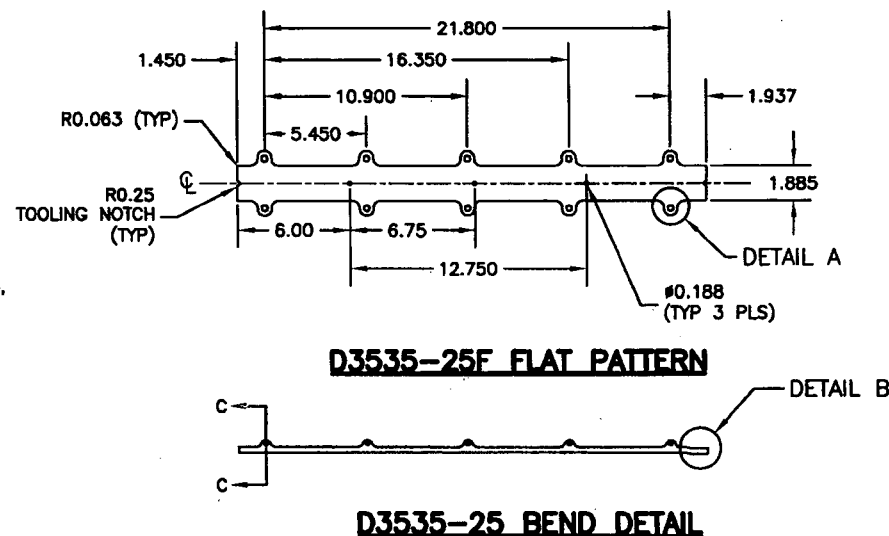
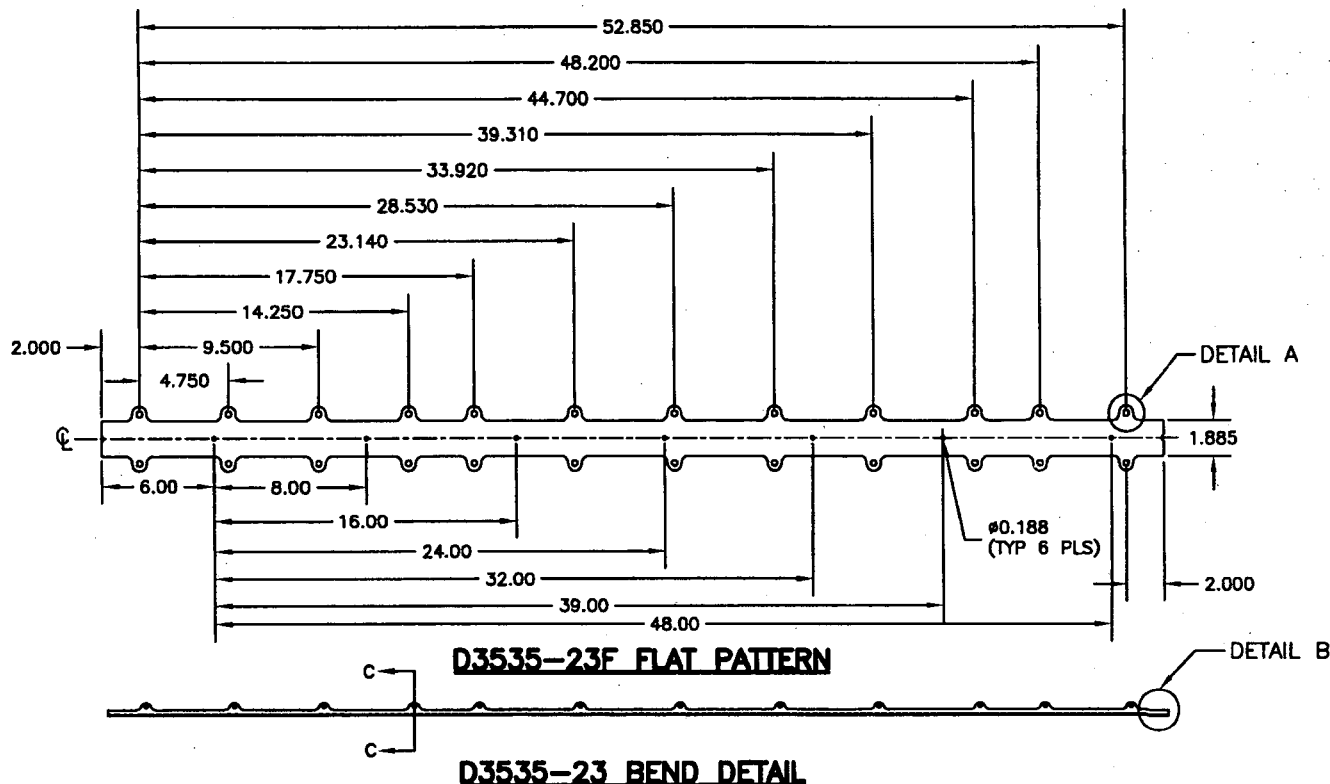
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NOTE: Date & initial all entries

DART

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07.04.24



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DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET 3 OF 7		
		REV. B		

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

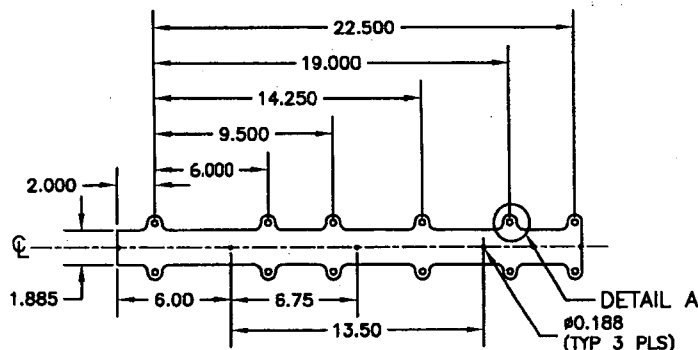
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DART

RELEASED
07.04.24

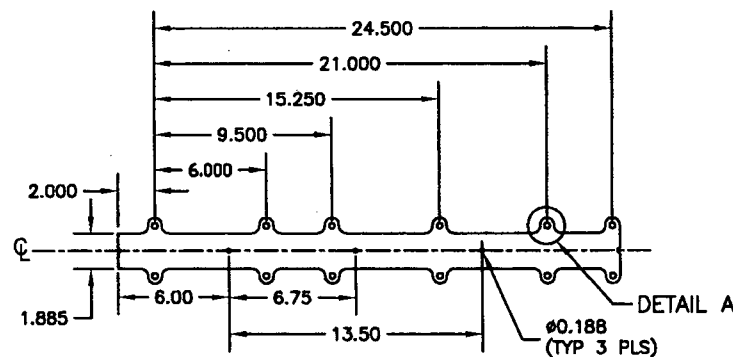
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
			D3535	
			SHEET 4 OF 7	
			SCALE	1:10



D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

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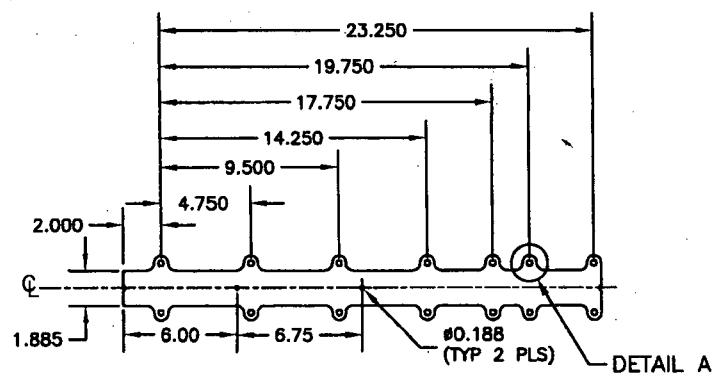
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07.04.17

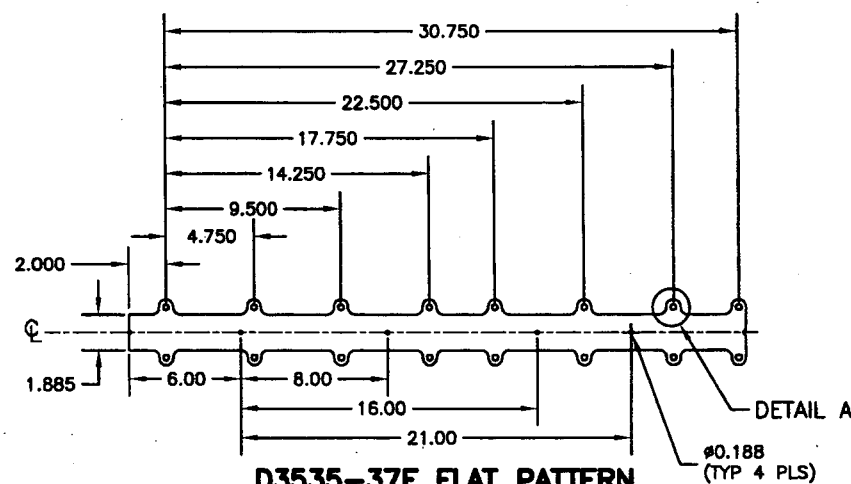
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 5 OF 7
DATE		D3535	SCALE
07.04.17		WEARSHOE	1:10



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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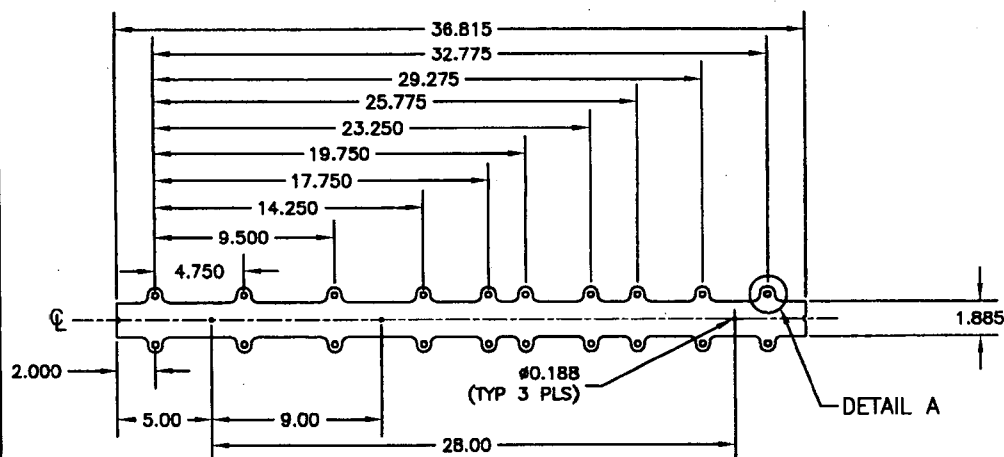
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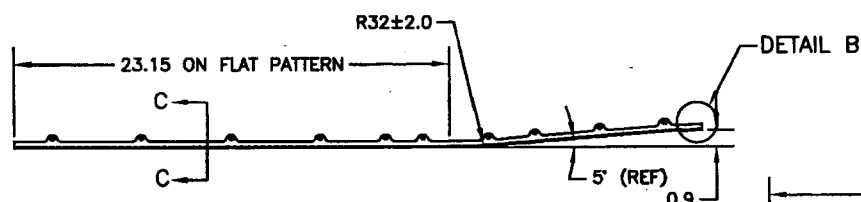
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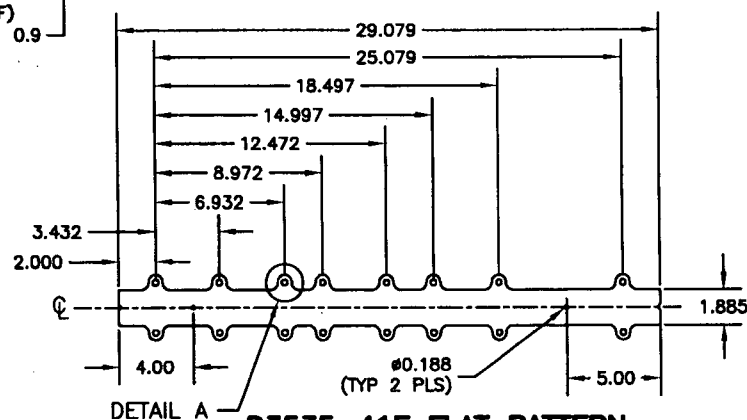
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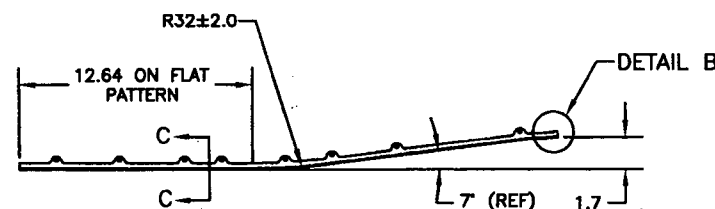
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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DESIGN	C.B.	DRAWN BY	AH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
TITLE	WEARSHOE	SHEET	6 OF 7	SCALE
				1:10

Dart Aerospace Ltd

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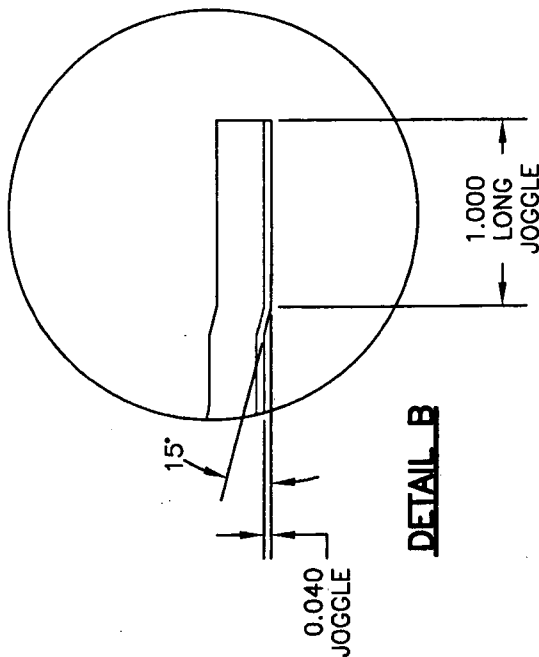
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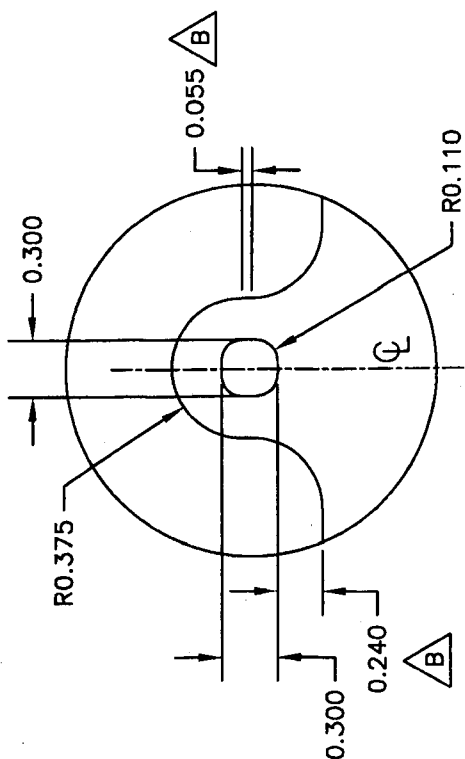
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

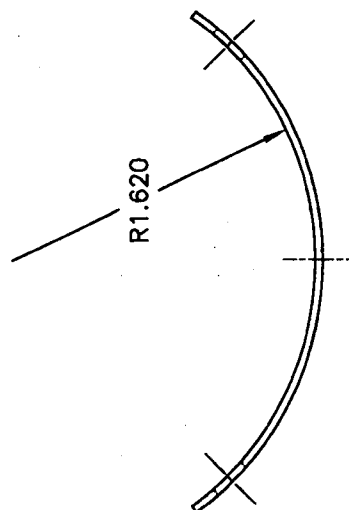
07.01.24



DETAIL B



DETAIL A



SECTION C-C

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries